



Date: Tuesday, 27/03/2007 10:00:57 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER
Job Number :	31516		
Estimate Number :	11178		
P.O. Number :	N/A	Part Number :	D32931
This Issue :	27/03/2007	Drawing Number :	D3293 REV A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	A
Previous Run :	31515	Material :	N/A
	Type :	Due Date :	03/04/2007
	SMALL /MED FAB	Qty:	10
Written By :		Um:	Each
Checked & Approved By :			
Comment :	Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S080	2024-T3 .080 sheet
-----	-------------	--------------------



Comment: Qty.: 1.9177 sf(s)/Unit Total : 19.1772 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080)
 Identify for D3293-1
 Batch: M102838

ml 07 03 27

(10)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3293
 Dwg Rev: A
 Prog Rev: A

ml 07 03 27

(10)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 03 27

(10)


4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

MS 07/03/28

(9)

 07/03/29 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: JD Date: 01/04/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/03/2007 10:00:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 31516

Part Number: D32931

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Deburr

DM 07/03/29 (9)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/29

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

M-L

07/03/30

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3-

M-L

07/03/30

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/04/02 (9)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/04/02 (9)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/04

Job Completion



U 07/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 04.06.28	DRAWING NO. D3293	REV. A
	TITLE DOUBLER	SHEET 1 OF 1
A	04.06.28	SCALE 1:3
	NEW ISSUE	

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

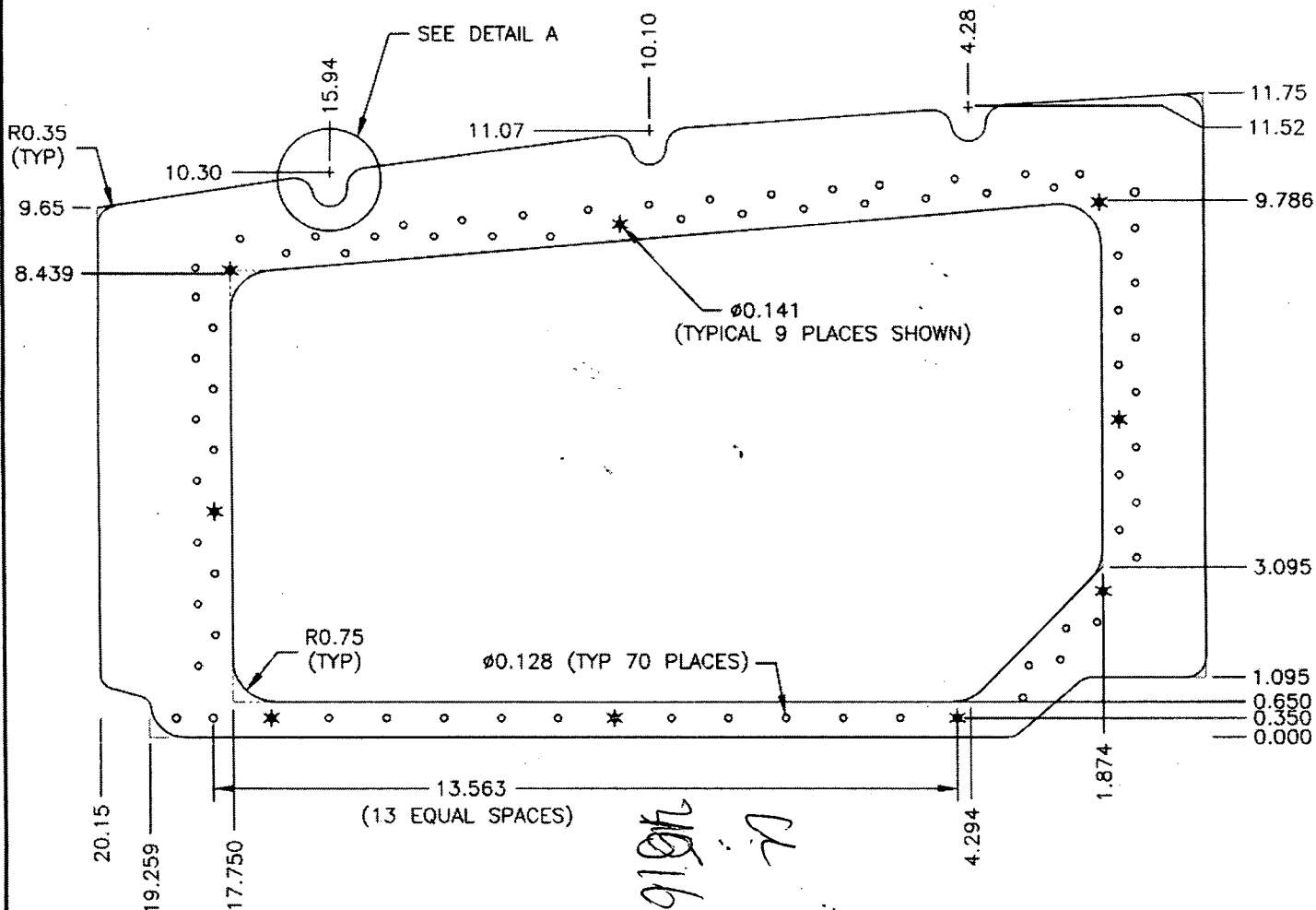
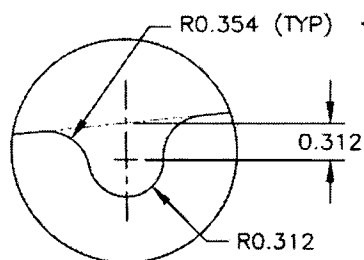
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04 07 12

DETAIL A SCALE 2:3



DART AEROSPACE LTD		Work Order: 31516
Description: Doubler		Part Number: D3293-1
Inspection Dwg: D3293 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 20.15	H-0.030	20.15 MS	✓		Measuring tape	
B Ø 0.141	+0.005-0.001	0.144	✓		vern	
C Ø 0.128	+0.005-0.001	0.132	✓		vern	
D 12.750	+/-0.030	12.750	✓		Measuring tape	
E 9.786	+/-0.010	9.790	✓		vern	
F 8.439	+/-0.010	8.440	✓		vern	
G R0.35	+/-0.030	R0.35	✓		RADIUS Gauge	
H 0.650	+/-0.010	0.650	✓		vern	
I 1.874	+/-0.010	1.878	✓		vern	
J 0.350	+/-0.010	0.348	✓		vern	
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>MM</i>	Audited by: <i>MS</i>	Prototype Approval:	N/A
Date: 01/03/21	Date: 01/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	